

Abstract Of The Disclosure

Process For Manufacturing A Toothbrush

5 A process for manufacturing hollow handled toothbrushes is disclosed. The process includes; a) providing a toothbrush mold having a head portion, a base portion, a toothbrush cavity located between said head and end portions and having walls, an injection port for molten plastic, and a gas injection port, wherein the gas injection port is positioned in the end of the base portion of the mold so that gas is injected
10 into the mold cavity substantially centrally thereof and in a direction parallel to the longitudinal axis of the mold; b) injecting a predetermined amount of a molten plastic into the mold cavity to partially fill the cavity; and c) injecting at least one gas through the gas injection port into the cavity to direct the molten plastic against the walls of the mold cavity.